

OK 67.70

Acid rutile MMA-electrode giving an over alloyed weld metal. Suitable for welding acid resistant stainless steels to mild and low alloyed steels. Also suitable for welding buffer layers when surfacing mild steel with acid resistant stainless steel weld metal.

Specifications	
Classifications	EN ISO 3581-A : E 23 12 2 L R 3 2 SFA/AWS A5.4 : E309LMo-17 CSA W48 : E309LMo-17 Werkstoffnummer : 1.4459
Approvals	ABS : SS to C- & CMn steels BV : 309Mo CE : EN 13479 CWB : E309LMo-17 DB : 30.039.05 DNV-GL : VL 309 Mo LR : SS/CMn RINA : 309Mo UKCA : EN 13479 VdTÜV : 02424

Welding Current	DC+, AC
Ferrite Content	FN 12-22
Alloy Type	Austenitic CrNi
Coating Type	Acid Rutile

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
ISO			
As Welded	510 MPa (74 ksi)	610 MPa (88 ksi)	32 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
ISO		
As Welded	20 °C (68 °F)	50 J (37 ft-lb)
As Welded	-20 °C (-4 °F)	35 J (26 ft-lb)

Typical Weld Metal Analysis %							
C	Mn	Si	Ni	Cr	Mo	N	Ferrite FN
0.02	0.6	0.8	13.4	22.5	2.8	0.09	18

Deposition Data					
Diameter	Current	Voltage	Deposition Efficiency (%)	Burn-off Time /Electrode	Deposition Rate @ 90% I max
2.0 x 300.0 mm (5/64 x 11.8 in.)	40-60 A	26 V	58 %	48 sec	0.6 kg/h (1.3 lbs/h)
2.5 x 300.0 mm (0.098 x 11.8 in.)	50-90 A	29 V	57 %	45 sec	0.9 kg/h (2.0 lbs/h)

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Deposition Data					
Diameter	Current	Voltage	Deposition Efficiency (%)	Burn-off Time /Electrode	Deposition Rate @ 90% I max
3.2 x 350.0 mm (1/8 x 13.8 in.)	60-120 A	27 V	59 %	61 sec	1.4 kg/h (3.1 lbs/h)
4.0 x 350.0 mm (5/32 x 13.8 in.)	85-180 A	31 V	61 %	56 sec	2.0 kg/h (4.4 lbs/h)
5.0 x 350.0 mm (0.197 x 13.8 in.)	110-250 A	30 V	59 %	64 sec	2.7 kg/h (6.0 lbs/h)